

ABSTRACT

A method and a device for manufacturing a synthetic resin coated metal can body capable of drawing and ironing the synthetic resin coated metal can body with a large processing quantity without causing can body breakage. First and second ironings are conducted to the side wall of a redrawn can (20) formed by drawing a thermoplastic resin-coated aluminum sheet (1) on both surfaces by a first ironing die (14) and a second ironing die (15) in that order according to the pressing-in of a punch (11) with such processing quantities that sheet thickness reduction ratios from an original sheet thickness come within the ranges of 35 to 55% and 60 to 75% respectively for manufacturing a metal can body. Since the coated layer of a thermoplastic resin acts on a metal body in a direction for preventing the metal body from being broken (ruptured), processing conditions for ironing are relieved, and even if an ironing with a high sheet thickness reduction ratio is performed, an ironing capable of maintaining quality is allowed without causing the can body breakage in a first step can (21) and a second step can (22).